Work Order ID 51277

August 13, 2009 10:55:31 AM

Item ID: D205-634-041 **Accept** **Setup Start**

Revision ID: D **Stop**

Item Name: Replacement Skidtube

Start Date: 8/13/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/13/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL JMC **Date:** 09/08/13 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002								
110	BENDING MACHINE - SKIDTUBES	0.00							
CNC Bend 1	**Memo**	0.00							
CNC Delta 100 Bender	1-Bend as per program D2580.C on CNC Bender and Folio FT009								
	2-Cut tubes as per Dwg. D2580								

Draw Nbr	Revision Nbr
D2580	Rev D

N/A

D

JM 9/8/24

Work Order ID 51277

August 13, 2009 10:55:31 AM

Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube

Accept

Setup Start
Stop

Start Date: 8/13/09 **Start Qty:** 1.00
Required Date: 10/13/09 **Req'd Qty:** 1.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes	**Memo**	0.00				D	MB	09-08-25	
Skidtubes	1- Deburr ends 2- C'sink holes as per dwg without cutting fluid 3- Prepare tube for welding, remove alodine as required. 4- Scribe batch number insied aft end of tube.								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

Work Order ID 51277

August 13, 2009 10:55:31 AM

Item ID: D205-634-041 **Accept** **Setup** **Start** **Stop**

Revision ID: D

Item Name: Replacement Skidtube

Start Date: 8/13/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/13/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
Skidtubes	**Memo**	0.00							

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod M111682 BE 09-08-26

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod M111682 BE 09-08-26

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

BE 09-08-27

Work Order ID 51277

August 13, 2009 10:55:31 AM

Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube

Accept

Setup Start
Stop

Start Date: 8/13/09 **Start Qty:** 1.00
Required Date: 10/13/09 **Req'd Qty:** 1.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00	=> 8 02/08/27			16	ϕ		
160 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	=> 8 02/08/27			16	ϕ		
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 **Memo**	0.00 0.00	=> 09/08/31			X1	ϕ		

Work Order ID 51277

August 13, 2009 10:55:31 AM

Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube

Accept

Setup **Start**
Stop

Start Date: 8/13/09 **Start Qty:** 1.00
Required Date: 10/13/09 **Req'd Qty:** 1.00
Reference:

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat						1	Ø		
Powder Coating	**Memo** M112260 START TIME: 2:15pm OVEN TEMPERATURE: 320°F FINISH TIME: 2:40pm	0.00 JM 09/08/31							
190	QC3- Inspect Part Finish	0.00 BL 09-09-3				1			
QC	**Memo**	0.00							
Quality Control									

Work Order ID 51277

August 13, 2009 10:55:31 AM

Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube

Accept

Setup Start
Stop

Start Date: 8/13/09 **Start Qty:** 1.00
Required Date: 10/13/09 **Req'd Qty:** 1.00
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R □□□ Sikaflex-291 112591 □□□
Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R □ □□ Sikaflex-291 112591 □□□
Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 112106

BL 09-09-10 ①

Work Order ID 51277

August 13, 2009 10:55:31 AM

Item ID: D205-634-041 **Accept** **Setup Start** **Stop**

Revision ID: D

Item Name: Replacement Skidtube

Start Date: 8/13/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/13/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
220	Packaging	0.00							
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPPD205-634-041 Location:_____ PPP Rev:_____								
230	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

2) Sos/09/10 (4) 6

51488 9/09/28 (12) 8

09/09/30

CL 09/09/30

Picklist Print

August 13, 2009 10:55:30 AM

Work Order ID: 51277

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD 205 Skidtube bent detail		Manufactured	No			110	Each	8.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code			
		B50976	D	M	9/8/24
Main Warehouse					
LG	6				
50757	6				
Main Warehouse					
ST	2				
50758	2				

D2576-3RevG Step (maching detail)		Manufactured	No			140	Each	147.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	147			
43504	46		1	SE 09-08-26
46661	101			

Picklist Print

August 13, 2009 10:55:30 AM

Work Order ID: 51277

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE Crossbolt Spacer		Manufactured	No			140	Each	92.0000	20.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	92	
43988	4	
46434	4	
46956	2	
47797	28	
48272	54	

B 51315 (×20) BE 09-08-26

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855RevA Cap		Manufactured	No			200	Each	37.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
FP6	37	
50513	37	

1 BR 09-09-10

Picklist Print

August 13, 2009 10:55:30 AM

Work Order ID: 51277

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A Bolt		Purchased	No			200	Each	2,540.000	2.0000			

Warehouse Location	Loc Qty	Loc Code	Qty Issued
Main Warehouse			
ST	2540		
100188	226		
105057 ✓	2246		2 BK 09-09-10.
15205	68		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L Washer		Purchased	No			200	Each	6,733.000	2.0000			

Warehouse Location	Loc Qty	Loc Code	Qty Issued
Main Warehouse			
ST	6733		
101291	16		
104885	153		
105793	236		
109632 ✓	1328		2 BK 09-09-10
110985	5000		

Picklist Print

August 13, 2009 10:55:30 AM

Work Order ID: 51277

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			200	Each	3,628.000	50.0000			
Insert												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	3628			
105855	16			
108606	52			
111529 ✓	1560			
111779 ✓	2000		56	BK 09-09-10.

AN3C4A		Purchased	No			200	Each	1,222.000	50.0000			
BOLT												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	1222			
112082 ✓	40		13	BK 09-09-10.
112314 ✓	1182		37	
112612.				

Picklist Print

August 13, 2009 10:55:30 AM

Work Order ID: 51277

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L washer		Purchased	No			200	Each	3,764.000	50.0000			

Warehouse Location	Loc Qty	Loc Code
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	3664	
112116 ✓	3664	

50 BR 09-09-10.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-13RevC Gasket		Manufactured	No			200	Each	29.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	29	
45717	1	
46889	2	
48166	10	
50265 ✓	16	

1 BR 09-09-10

Picklist Print

August 13, 2009 10:55:30 AM

Work Order ID: 51277

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-5RevC Gasket		Manufactured	No			200	Each	4.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse	51260		1	BR 09-09-10
ST		4		
36113		1		
46186		1		
47318		1		
48167		1		

D3566-1RevC Gasket		Manufactured	No			200	Each	13.0000	2.0000			

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST		13		
46349		1		
47434		2		
48557		3		
51218		7		
51612			2	BR 09-09-10

Picklist Print

August 13, 2009 10:55:30 AM

Work Order ID: 51277

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-11RevD		Manufactured	No			200	Each	15.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code	Qty Issued	Date Issued
Main Warehouse 51256			1	BR 09-09-10.
ST	15			
45823	1			
48553	4			
50112	10			

D3564-13RevD		Manufactured	No			200	Each	39.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code	Qty Issued	Date Issued
Main Warehouse				
FP17	24			
48554	2			
50270	22		1	BR 09-09-10
Main Warehouse				
ST	15			
45409	3			
46495	10			
47867	2			

Picklist Print

August 13, 2009 10:55:30 AM

Work Order ID: 51277

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD Wearshoe		Manufactured	No			200	Each	3.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse	51258	
ST		3
44659		1
45825		1
48556		1

1 BR 09-09-10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD Wearshoe		Manufactured	No			200	Each	6.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code
OFFSHORE		
FG		2
34806		2
Main Warehouse		
FP19		2
48555		2
Main Warehouse		
ST		2
45824		1
47433		1
51655		

1 BR 09-09-10

Picklist Print

August 13, 2009 10:55:30 AM

Work Order ID: 51277

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC O-Ring, 205 Skidtube		Manufactured	No			200	Each	670.0000	16.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	670	
27168	44	
29908	626	

16 BR 09-09-10.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC Plug, 205 Skidtube		Manufactured	No			200	Each	476.0000	16.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	476	
42221	16	
42807	92	
43884	3	
46435	2	
~~47251~~	363	

ST757.

16. BR 09-09-10.

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS

A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

RELEASED 07.06.28

QTY -041	QTY -045	Part Number	Description
X		**D2580-041**	**SKIDTUBE ASSEMBLY**
	X	**D2580-045**	**SKIDTUBE ASSEMBLY**
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51277

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
   SEE NOTES ON
   PAGE 2 FOR D2580-041 AND
   PAGE 3 FOR D2580-045
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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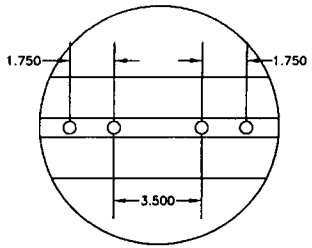
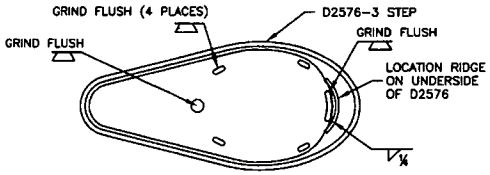
DETAIL A
SCALE 5:24

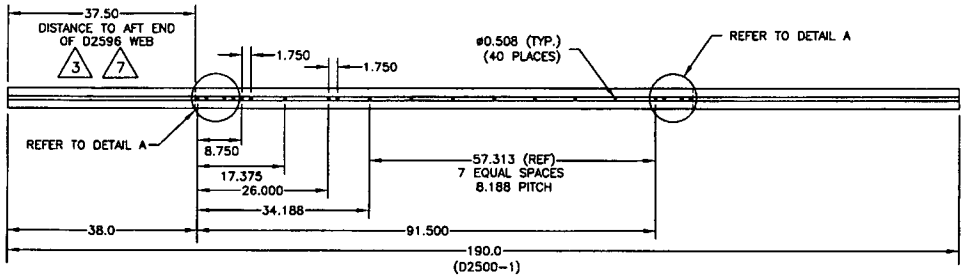


RELEASED
07 de 28

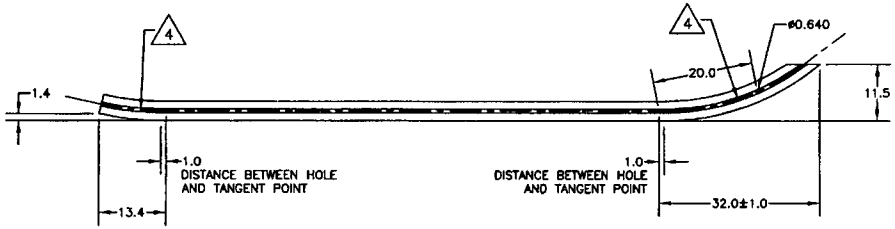
DETAIL B
SCALE 5:24



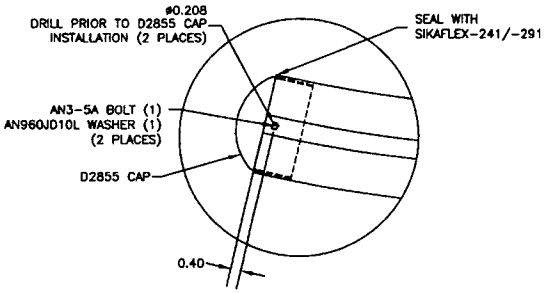
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



DETAIL C
SCALE 5:24



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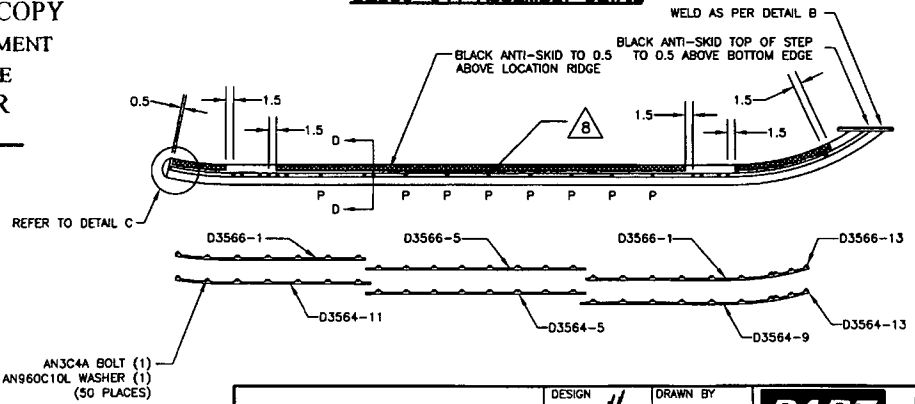
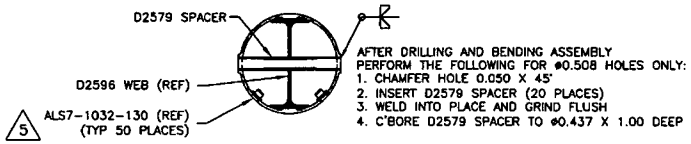
NO. 51277

D2580-041 ASSEMBLY DETAIL



SECTION D-D
SCALE 5:24



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP

D2580-041 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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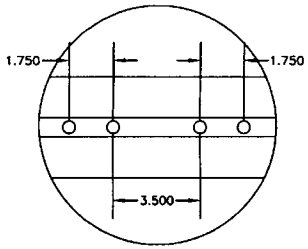
DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 2 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24

DETAIL E
SCALE 5:24



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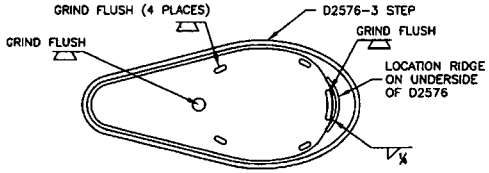
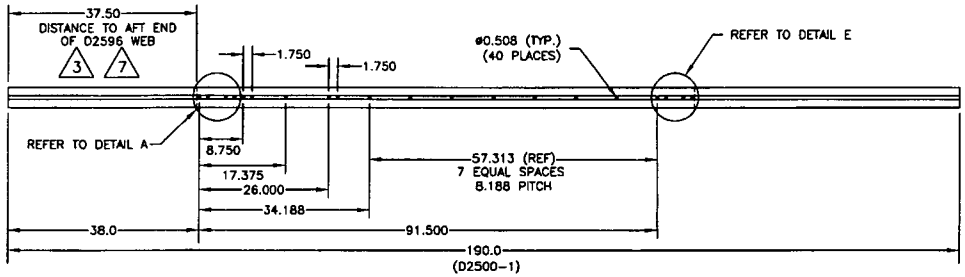
07 02 28

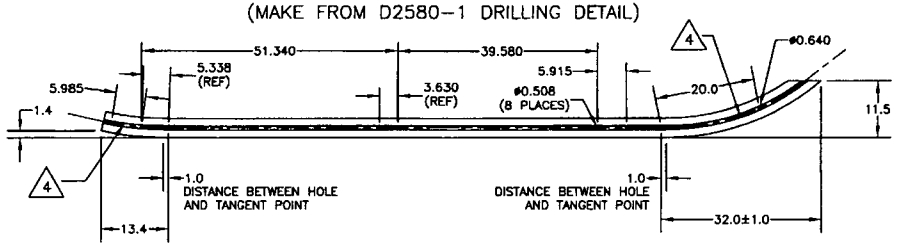
DETAIL F
SCALE 5:24



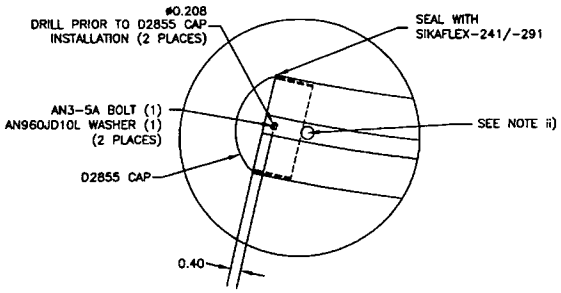
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



DETAIL G
SCALE 5:24



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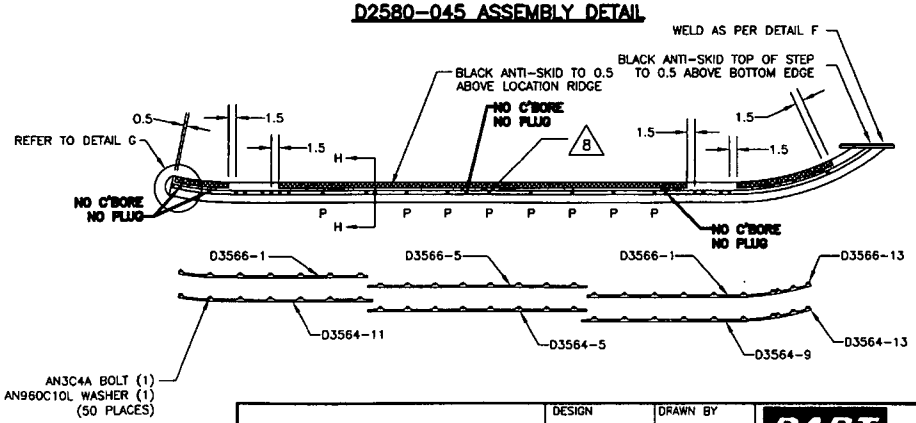
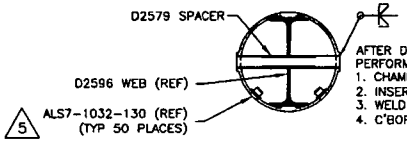
D2580-045 ASSEMBLY DETAIL



SECTION H-H
SCALE 5:24



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP

C

D2580-045 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN: RJH	DRAWN BY: RJH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED:	APPROVED:	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE: 07.02.27		TITLE: 205 SKIDTUBE ASSEMBLY	SCALE 1:24

NO. 206

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 50844
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig[✓] Mig[ ]
Base materiel: Aluminium
Current: AC[✓] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓]	fail[ ]
Penetration:	pass[✓]	fail[ ]

UNACCEPTABLE

Cracks:	pass[✓]	fail[ ]
Undercut:	pass[✓]	fail[ ]
Pin holes:	pass[✓]	fail[ ]
Overlap (cold lap)	pass[✓]	fail[ ]
Porosity (surface):	pass[✓]	fail[ ]
Coloration:	pass[✓]	fail[ ]

Qualifier [signature] **Date of Test Coupon** 09-08-13

Welder [signature] **Date of Test Coupon** 09-08-13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld